

Work Order ID 62590

Monday, October 04, 2010 3:49:45 PM

Page 1

Item ID: D2731-7

Accept

Setup Start

Revision ID:

Item Name: Mounting Lug

Stop

Start Date: 10/5/2010 Start Qty: 20.00

Required Date: 10/29/2010 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: mf

Date: 10-10-04

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2731

Rev C

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

0.00

Cut D2423 extrusion to .82"

Batch

C2 10/10/07 20

Issue PO 12709
Machine per drawing D2731 Rev C

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

1-Machine as per folio FA930

DWG REV:

FOLIO REV:

2-Check for crack while loading into the machine

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Required Date:	10/29/2010	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2 - Inspect parts off machine FAI/FAIB <i>Receive & inspect for transit damage</i> <i>Ensure C of C attached</i> Memo	0.00 0.00							<i>Per 10/18</i> (20)
130  QC Quality Control	QC8 - Inspect parts - second check <i>QC6</i> Memo	0.00 0.00				<i>20</i>			<i>10-10-18</i>
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>20</i>	<i>9</i>		<i>10/10/19</i>

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Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

155

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B115967

PAINT DELFLEET BLUE B 115504

CLEAR DELFLEET BLUE B 115506

W 10 10 27 (20)

165

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

S 10 10 28 (+20)

170

Identify as per dwg & Stock Location: 1

0.00



Packaging

Memo

0.00

Packaging

C/p/c/28 (20)

W/O:		WORK ORDER CHANGES					
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Item ID: D2731-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 10/5/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/28 JF

WF
10-10-28

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, October 04, 2010 3:49:45 PM

Page 1

Work Order ID: 62590



Parent Item: D2731-7



Parent Item Name: Mounting Lug



Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP ☐ D ☐ 00.05.19 ☐ Added inspect level 8, removed P/O powder coating ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-7P 		Purchased	No			100	Each	0.0000	1	20			
LUG													
D2423 		Manufactured	No			110	f	344.4990	0.0683	1.437895			
Lug Extrusion													

MF 10-10-28

Location

MAT06

43722
45800

Loc Qty

344.4989795
180
64.498979

Loc Code

MF 10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

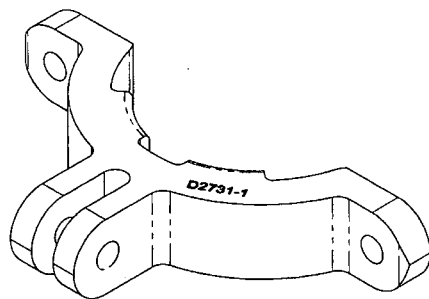
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

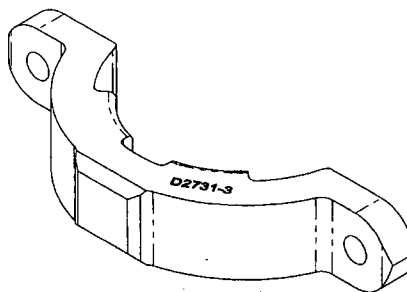
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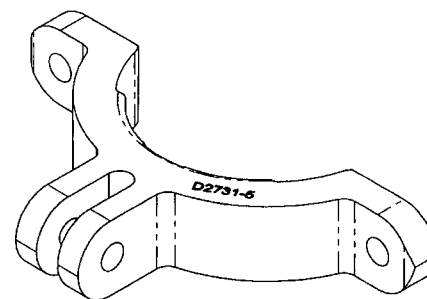
#62590



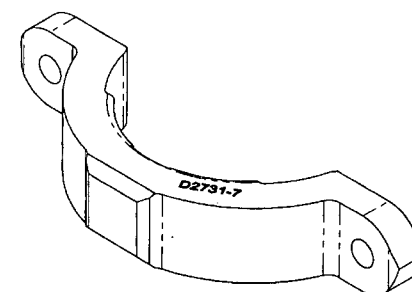
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

RELEASED
CP/DA/5/14P

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
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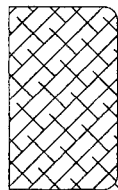
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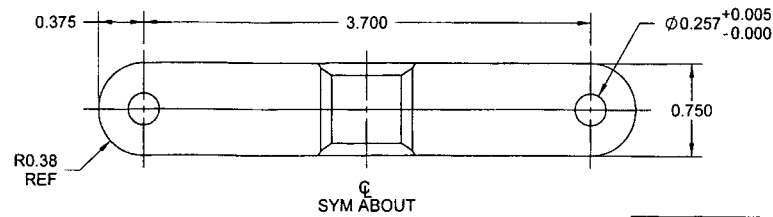
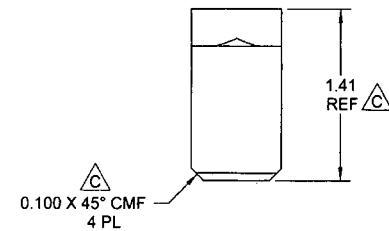
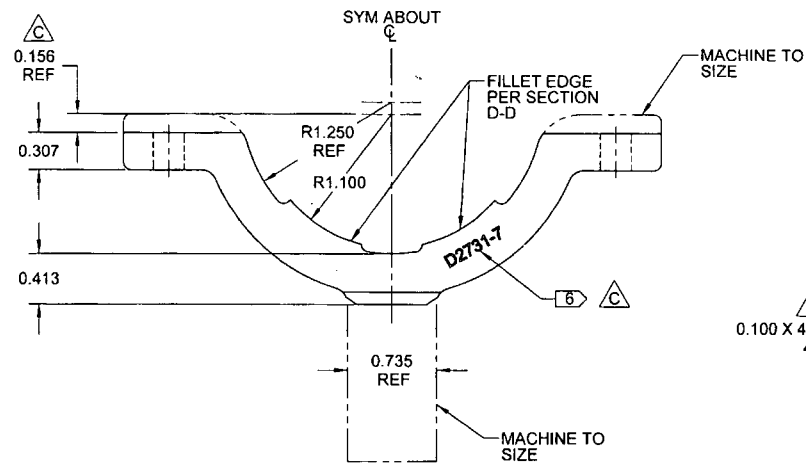
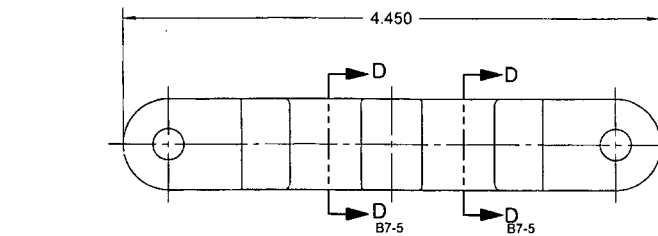
NOTE: Date & initial all entries

#62590

SECTION D-D D4-5
SCALE 2X



R0.06 MIN-R0.10 MAX
2 PL



D2731-7 MOUNTING LUG

RELEASED
09/06/25

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMINGATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO12709

Purchase Order Date 10/07/10

PO Print Date 10/07/10

Page Number 1 of 3

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
C. Lavoie

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3394-3P	Lug	10/15/10 Yes	40.00 Each	Yours ppd	\$17.4500	\$698.00
		Special Inst:	MACHINE AS PER DWG D3394 REV. B B62667				
2	D3394-3P	Lug	10/15/10 Yes	24.00 Each	Yours ppd	\$17.4500	\$418.80
		Special Inst:	AS ABOVE B62589				
3	D2731-7P	LUG	10/15/10 Yes	24.00 Each	Yours ppd	\$12.4000	\$297.60
		Special Inst:	MACHINE A SPER DWG D2731 REV. C B62402				
4	D2731-7P	LUG	10/15/10 Yes	20.00 Each	Yours ppd	\$12.4000	\$248.00
		Special Inst:	AS ABOVE				

10/07/10

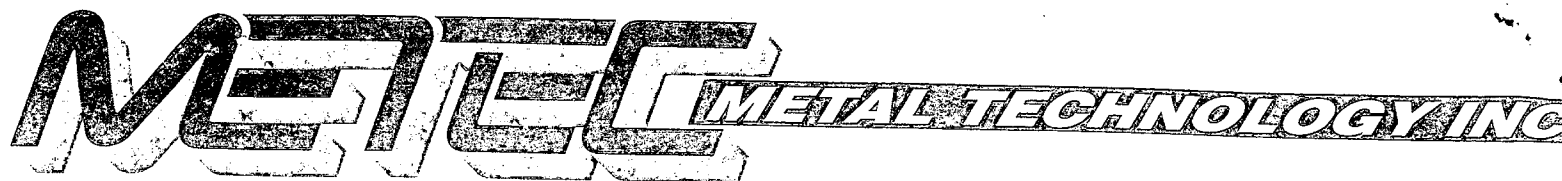


20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **17514**
Date: Oct 15, 2010
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 12709	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3394-3 Lug as per drawing D3394 Rev.B Material supplied by DART D2423 B45800	Each	40	40	
D3394-3 Lug as per drawing D3394 Rev.B Material supplied by DART D2423 B45800	Each	24	24	
D2731-7 Lug as per drawing D2731 Rev.C Material supplied by DART D2423 B45800	Each	24	24	
D2731-7 Lug as per drawing D2731 Rev.C ✓ Material supplied by DART D2423 B45800	Each	20	20	
D2230-3 Mounting Lug as per drawing D2230 Rev.G Material supplied by DART D2423 B45800	Each	100		100
D2230-3 Mounting Lug as per drawing D2230 Rev.G Material supplied by DART D2423 B45800	Each	80		80
D3235-1 Mounting Lug as per drawing D3235 Rev.A Material supplied by DART D2423 B45800	Each	50		50
D2230-1 Mounting Lug as per drawing D2230 Rev.G Material supplied by DART D2423 B45800	Each	100		100
D4091-1 Lug as per drawing D4091 Rev.A Material supplied by DART D2423 B45800	Each	10		10
Received by _____	Thank you for your order!			



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3394-3	Mounting Lug	12709
24	D3394-3	Mounting Lug	12709
24	D2731-7	Mounting Lug	12709
20	D2731-7	Mounting Lug	12709 —

MATERIAL: Supplied by DART D2324 45800 ✓

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, October 15, 2010